Date

Friday, 06/03/2009 8:50:37 AM

User:

Linda Lacelle

Process Sheet

Customer Job Number

: CU-DAR001 Dart Helicopters Services

S.O. No. :

: 46314

Estimate Number

: 10513

P.O. Number

This Issue

: 06/03/2009

Prsht Rev. : NC

First Issue **Previous Run**

: 41707

: //

Type

Revised Finishing step to Acid etch and

: MACHINED PARTS

Project Number Drawing Revision

Material

Drawing Name

Part Number

Drawing Number

Due Date

Description:

6061-T6 Bar 1.50 x 1.50

: 13/03/2009

: STOP

: D28052

: N/A

: B

. D2805 REV. B

Qty:

12 Um:

Each

Checked & Approved By

Comment

Written By

B 00.11.14 : Est:

Alodine EC

Additional Product

Job Number:

Seq. #:

1.0

Machine Or Operation:

M6061T6B1500X01500

Comment: Qty.:

Total: 0.2756 f(s)/Unit

3.3075 f(s)

6061-T6 Bar 1.5" x 1.5"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5" Batch: M 108962

(M6061T6B1500X01500)

BAND SAW

2.0

BAND SAW

Comment: BAND SAW

+0.010/-0.030" Cut Bar: 3.150" Long

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA104 and Dwg D2805

2- Tumble and Deburr Identify as D2805-2

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK



Form: rprocess

Page 1

Dart Aerospace	Ltd
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W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES							
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
·										
			:							
•										

Part No: _		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:
NCR:		WOF	RK ORDER NON-CONFO	PRMANCE (NCR)	
	· _		Corrective Action	Section B	

		Description of NC		Verification	Annuoval	A 1		
DATE	STEP	STEP Section A Initial Action Descri	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
		191			· ·			

NOTE: Date & initial all entries

Date: Friday, 06/03/2009 8:50:38 AM Uśer: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: STOP Job Number: 46314 Part Number: D28052 Job Number: Seq. #: **Machine Or Operation: Description:** HAND FINISHING1 6.0 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 7.0 QC3 Comment: INSPECT ALODINE 8.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: \(\square\) 9.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart /	Aerosp	ace L	_td
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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No: _	:	PAR #: Fault Category:		NCR: Y	es No DC	QA:	Date: _	
	F	esolution:	Disposition:	QA: N/C	Closed: _		Date: _	

NCR:		V	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B			A	A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
					,						
_											
		•				5					

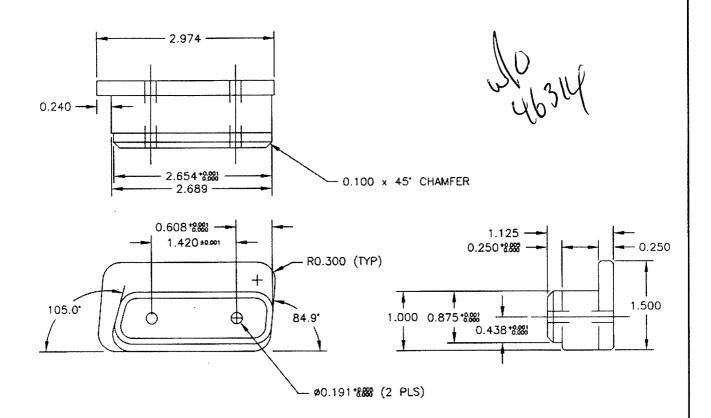
NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	46314
Description: Stop	Part Number:	D2805-2
Inspection Dwg: D2805 Rev: B		Page 1 of 1

	FIRS	T ARTICLE II	NSPECTI	ON CH	ECKLIST		
	X	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		mments
2.974	+/-0.010	2.975					
0.240	+/-0.010	240					
0.100 chamfer	+/-0.010	.0917					
1.420	+/-0.001	1.420					
1.125	+/-0.010	1.127	/				
0.250	+0.005/-0.000	.253	/				
0.250	+/-0.010	.249					
1.500	+/-0.010	1.500	/				
1.000	+/-0.010	.999	/				
0.875	+0.001/-0.000	.8755	//				
0.438	+0.001/-0.000	.438					
		·					
		-					
		-					
_							
		,					
			08				
Measured by:	11	Audited by:			Prototype /		N/A
Date:	09/03/12	Date:	09/05/	17		Date:	N/A
Rev Date	Change		_/_/			Revised by	Approx/ed
A 05.04.26	New Issue					KJ/JLM A	- (////



DESIG	*	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA)
CHECK	ED,	APPROVED	DRAWING NO.	REV. B
	#	-	D2805 SHEE	T 1 OF 2
DATE		material and an arrange of the second	TITLE	SCALE
01.0	3.13		STOP	2:3
 Α		00.10.31	NEW ISSUE	
В	,	01.03.13	ADD -3/-4	



D2805-1 (SHOWN) D2805-2 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED. BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED. MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) FINISH: CHEMICAL CONVERSON COAT PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			

Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:	_
	Resolution:		Disposition:	QA: N/C Closed	:	Date:	

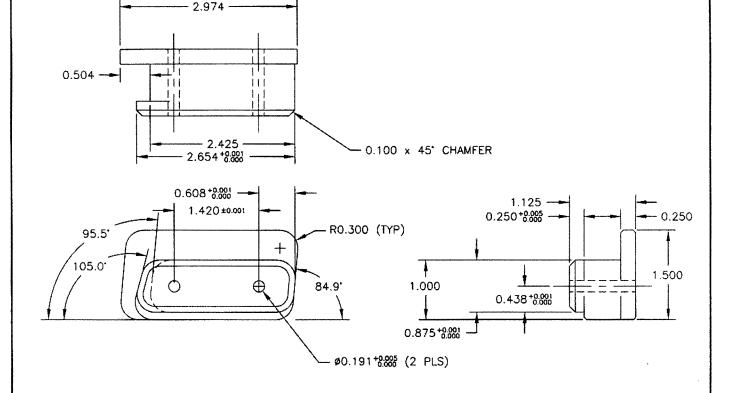
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification	Approval	Approval	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	

NOTE: Date & initial all entries



DESIGN	DRAWN BY		ROSPACE LTD LY, ONTARIO, CANADA
CHECKED,	APPROVED	DRAWING NO.	REV. B
eff	4	D2805	SHEET 2 OF 2
DATE		TITLE	SCALE
01.03.13		STOP ·	2:3





D2805-3 (SHOWN) D2805-4 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED. BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED. MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) FINISH: CHEMICAL CONVERSON COAT PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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